



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3201-1
Job Sheet 183644



Part No: D3201-1

Job Qty: 5 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 9/28/18

Created By: Shannon Hadley

Type: Stock

Description:

Note: DWG REV B IPP Rev:A Removed from 9 Digit 06-01-25 JLM IPP Rev:B Now on Waterjet 06-08-14 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	5 pcs		9/28/18	0.00	0.19	Waterjet 1		SC 18/10/18
120	QC	5 pcs		9/28/18	0.00	0.00	QC8		OCT 1 5 2018
140	HandFinish	5 pcs		9/28/18	0.00	0.19	HandFinish1		D.R 18/10/18
150	QC	5 pcs		9/28/18	0.00	0.00	QC7-2		38
160	Packaging	5 pcs		9/28/18	0.00	0.00	Packaging3	5/10/23	OCT 2 2 2018
170	QC21-SA	5 Ea		9/28/18	0.00	0.00	QC21		OCT 2 3 2018

Part Op 100 - 1-Cut as per Dwg D3201
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	1.3800 sf (.276 ea)	100-Waterjet	5114546

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M2024T3S.040	1	43	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.500inches $\pm$ 0.030	0.530 0.470		
2	Doubler	3.570inches $\pm$ 0.030	3.600 3.540		
3	Doubler	0.120inches $\pm$ 0.030	0.150 0.090		
4	Doubler	8.000inches $\pm$ 0.030	8.030 7.970		
5	Doubler	0.580inches $\pm$ 0.030	0.610 0.550		
6	Doubler	4.890inches $\pm$ 0.030	4.920 4.860		
7	Doubler	0.250inches $\pm$ 0.030	0.280 0.220		
8	Doubler	0.040inches $\pm$ 0.010	0.050 0.030		

Plex 9/21/18 3:44 PM Dart.Hadley.Shannon

DART
AEROSPACE
Container No: S118070
Part: D3201-1
Job No: 183644
Serial No/Batch: S118070
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 10/14/18
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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D3201-1
Job Sheet 183353



Part No: D3201-1

Job Qty: 5 ea

Part Name: Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/17/18

Job Tracking No:

Due Date: 9/28/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP Rev:A Removed from 9 Digit 06-01-25 JLM IPP Rev:B Now on Waterjet 06-08-14 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		9/28/18	0.00	0.00	Start Up Waterjet		
100	Waterjet	5 pcs		9/28/18	0.00	0.19	Waterjet1		
120	QC	5 pcs		9/28/18	0.00	0.00	QC8		
140	HandFinish	5 pcs		9/28/18	0.00	0.19	HandFinish1		
150	QC	5 pcs		9/28/18	0.00	0.00	QC7-2		
160	Packaging	5 pcs		9/28/18	0.00	0.00	Packaging3		
170	QC21-SA	5 Ea		9/28/18	0.00	0.00	QC21		

Part Op
Descriptions: **100** - 1-Cut as per Dwg D3201

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	1.3800 sf (.276 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	1	43	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.500inches $\pm$ 0.030	0.530 0.470	0,505	
2	Doubler	3.570inches $\pm$ 0.030	3.600 3.540	3,576	
3	Doubler	0.120inches $\pm$ 0.030	0.150 0.090	0,125	
4	Doubler	8.000inches $\pm$ 0.030	8.030 7.970	8,007	
5	Doubler	0.580inches $\pm$ 0.030	0.610 0.550	0,579	
6	Doubler	4.890inches $\pm$ 0.030	4.920 4.860	4,891	
7	Doubler	0.250inches $\pm$ 0.030	0.280 0.220	0,252	
8	Doubler	0.040inches $\pm$ 0.010	0.050 0.030	0,040	

Plex 9/17/18 10:10 AM Dart.Gagnon.Michelle